

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION <div style="display: flex; justify-content: space-around;"> <div> <input type="checkbox"/> Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved </div> <div> <input type="checkbox"/> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab </div> <div> <input type="checkbox"/> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite </div> <div> <input type="checkbox"/> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier </div> <div> <input type="checkbox"/> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other </div> </div>
--	---

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Equip/Tooling									
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Material									
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Offset/Setup									
Process									
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Training									
Transport									
Unapproved									

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Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

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Work Order ID 122245

Monday, July 14, 2014 1:53:57 PM

122245

Page 4

Item ID: 647.0112 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Strut Bracket
Start Date: 7/18/14 Start Qty: 35.00 ***35*** Cust Item ID:
Required Date: 7/18/14 Req'd Qty: 35.00 ***35*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

MLJ 14-08-25
MLJ 14-08-25

DQA: _____ Date: _____



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Picklist Print

Monday, July 14, 2014 1:53:57 PM

Page 1

Work Order ID: 122245

122245

Parent Item: 647.0112

647 0112

Parent Item Name: Strut Bracket

Start Date: 7/18/14

Required Date: 7/18/14

Start Qty: 35.00

Required Qty: 35.00

Comments: IPP REV:A 12.08.14 NEW ISSUE DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S14GA		Purchased		No		100	sf	72.7500	0.0325	1.197368			
M304S14GA									**				
304SS sheet .080													

DAS
46

9-89

14/08/10

Location

MAT020

M126075

Loc Qty

72.75

72.75

Loc Code

L.I.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

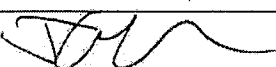
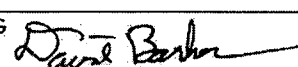
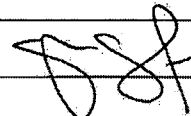
Work Order update only ☐

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Equip/Tooling									
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FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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APICAL INDUSTRIES, INC.	ENGINEERING CHANGE NOTICE NO. 03985			SHEET 1 OF 2	
	DWG NO. 647.0100	REV: A	PREPARED BY J. BECKER	DATE: 7/15/13	EFFECT ON DWG <input type="checkbox"/> INC. <input checked="" type="checkbox"/> UNINC.
	DWG TITLE: SHEET METAL				
APPROVED BY: ENGR. 		MFG 	QC 	EFF. NEXT ORDER	
TRANSACTION CODES (TC): A-ADD C-CREATE R-REVISE D-DELETE	REASON: REVISED NOTE 2. ADDED 647.0117				

IS

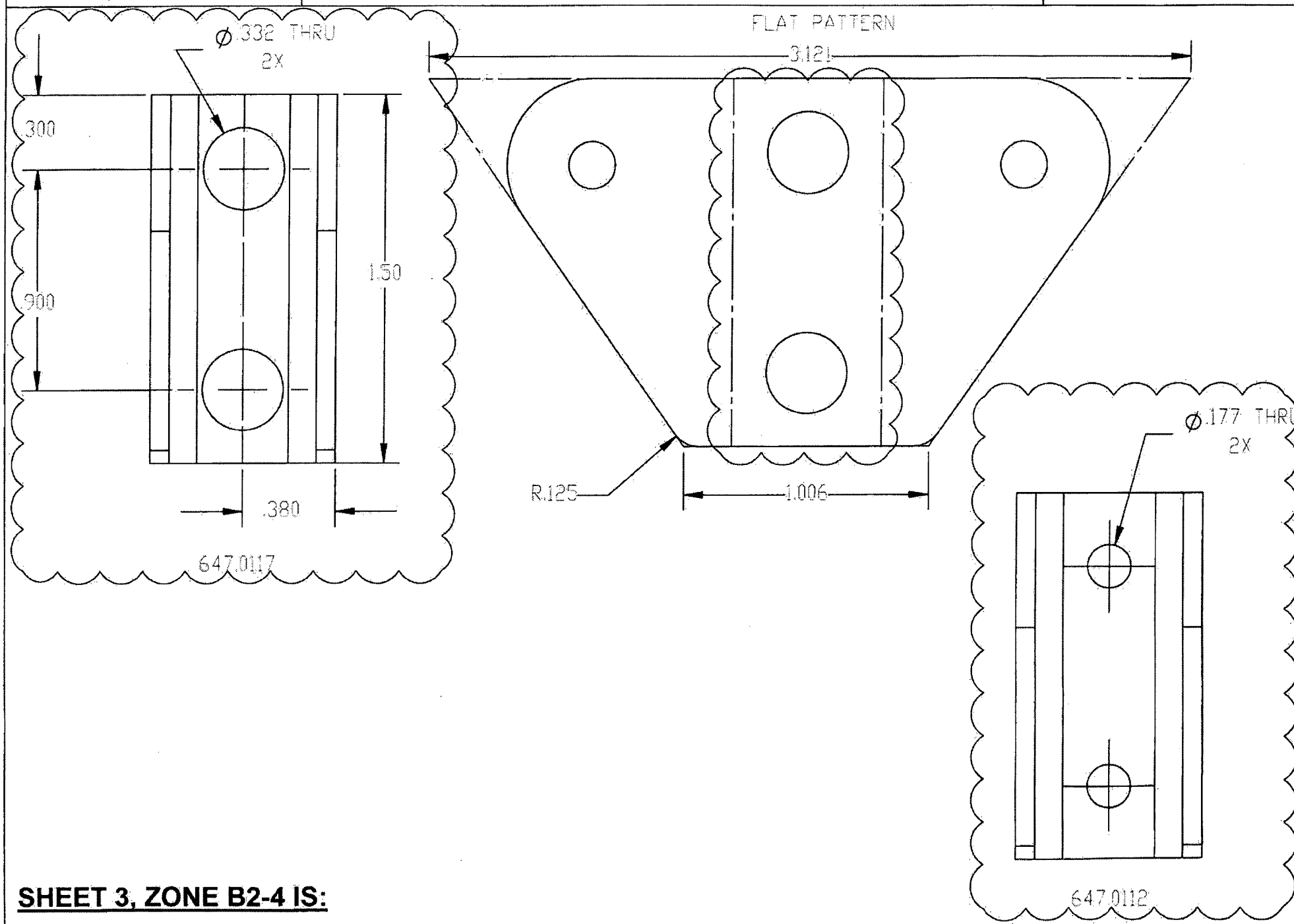
NOTES:

- 1 MATERIAL: ALUMINUM 2024-T3 PER AMS-QQ-A-250/4.
- 2 FINISH: IAW MPP-172 ANODIZE IAW SECTION 2.1,
PRETREATMENT IAW SECTION 3.1
AND PRIMER IAW SECTION 4.1.
3. DEBURR AND BREAK ALL SHARP EDGES.
4. IDENTIFY IAW MPP-120.
- 5 MATERIAL: 304 SS IAW AMS 5643.
- 6 FINISH: PRIME IAW MIL-P-23377J TYPE I CLASS N.
- 7 OTHER DIMENSIONS SAME AS 647.0112.

THIS COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 122245 MWS
 1407-14

SHEET 1, ZONE D1 IS:

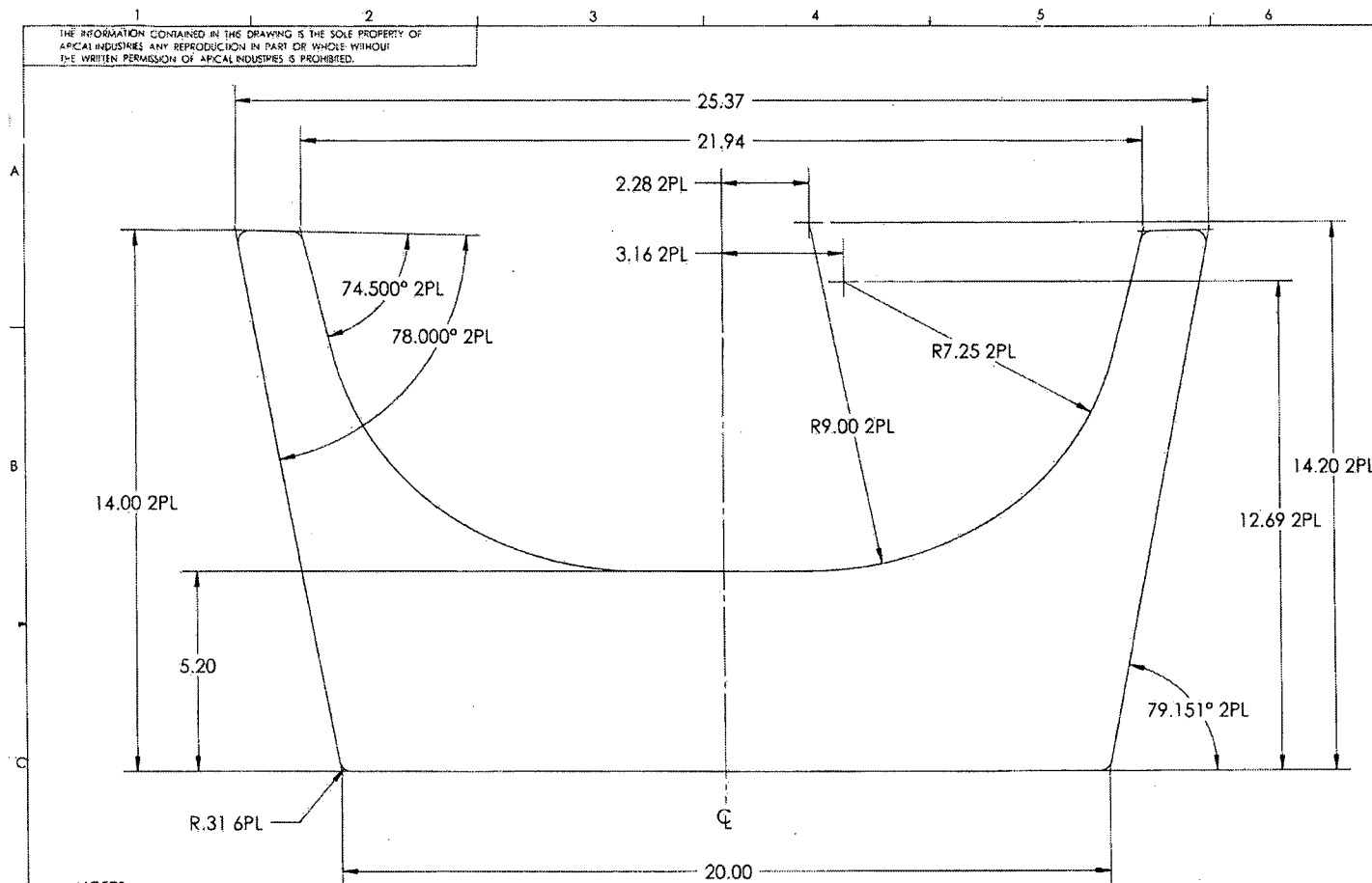
C	647.0117	STRUT BRACKET		△	△
F/NTC	PART NUMBER	DESCRIPTION		MATERIAL	SPECIFICATION
DOCUMENTS EFFECTED:		CHANGE CATEGORY		DER REVIEW REQUIRED	
<input type="checkbox"/> MDL <input type="checkbox"/> INSTALL INSTRUCTIONS <input type="checkbox"/> ICA <input type="checkbox"/> FMS <input type="checkbox"/> BOM		<input type="checkbox"/> MAJOR <input checked="" type="checkbox"/> MINOR		<input type="checkbox"/> YES <input checked="" type="checkbox"/> NO	



SHEET 3, ZONE B2-4 IS:

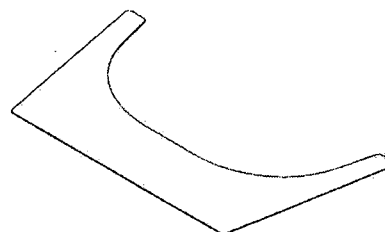
THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF APICAL INDUSTRIES. ANY REPRODUCTION IN PART OR WHOLE WITHOUT THE WRITTEN PERMISSION OF APICAL INDUSTRIES IS PROHIBITED.

REVISIONS			
REV	DESCRIPTION	DATE	APPROVED
1	LAST PROTOTYPE REVISION PP2		N/C
N/C	INITIAL RELEASE	03/28/09	P. BRAVO
A	INCORPORATED ECN 02722, 02764, 03009	04/28/11	P. BRAVO



NOTES:

1. MATERIAL: ALUMINUM 2024-T3 PER AMS-QQ-A-250/4.
2. FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK; PRETREAT PR-148 ADHESION PROMOTER; PRIME IAW MIL-P-23377J TYPE I CLASS N.
3. DEBURR AND BREAK ALL SHARP EDGES.
4. IDENTIFY IAW MPP-120.
5. MATERIAL: 304 SS IAW AMS 5643.
6. FINISH: PRIME IAW MIL-P-23377J TYPE I CLASS N.



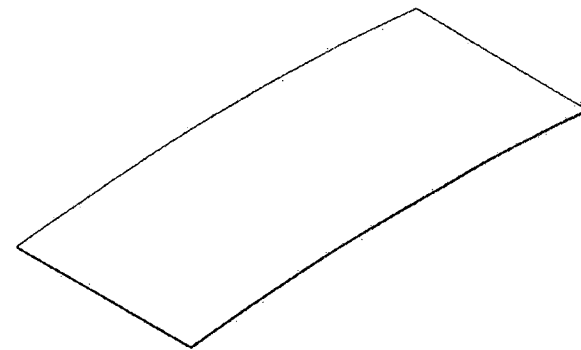
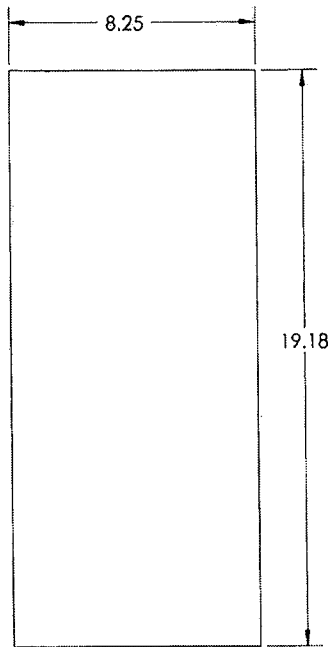
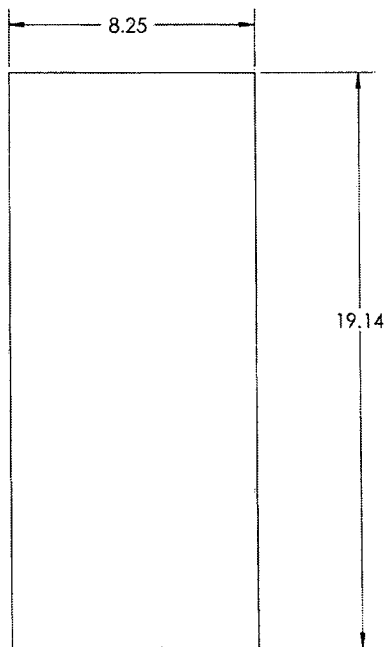
647.0110

UNINCORPORATED ECN(S)

03985

		647.0116	DOUBLER	△	△
		647.0115	CLIP	△	△
		647.0114	CLIP	△	△
		647.0113	STRUT DOUBLER	△	△
		647.0112	STRUT BRACKET	△	△
		647.0111	PANEL	△	△
		647.0110	ROOF DOUBLER	△	△
	FIND #	PART #	DESCRIPTION	MAT'L	SPEC.
QTY		PARTS LIST			
NEXT ASSY (S)		APICAL INDUSTRIES			
646.9500		2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300			
		SHEETMETAL			
		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 3 PLACE DECIMALS ± .01 2 PLACE DECIMALS ± .005 ANGLES ± .5°			
REV	DATE	DWG	REV	DATE	
B	07M26	647.0100	A		
SCALE NONE		SHEET 1 OF 6			

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647.0111

FLAT PATTERN



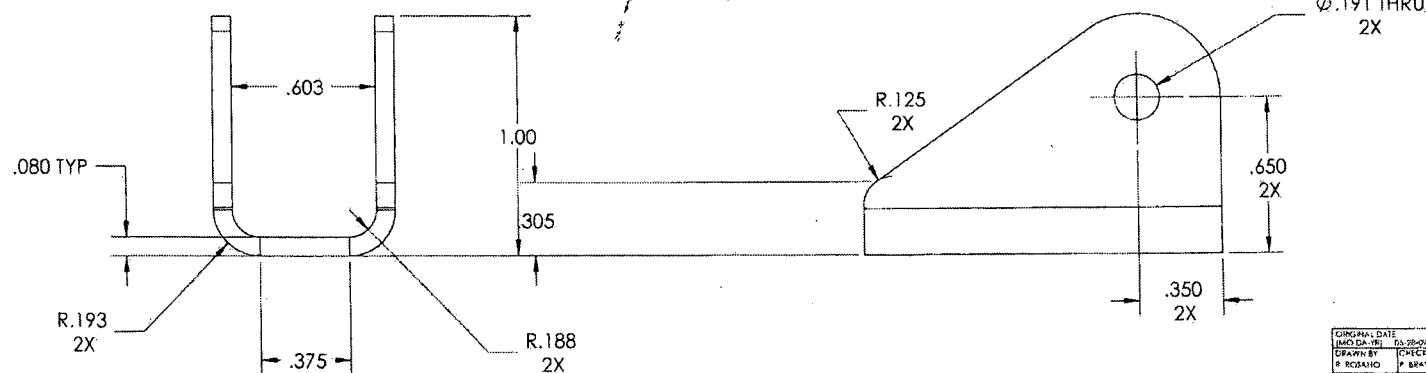
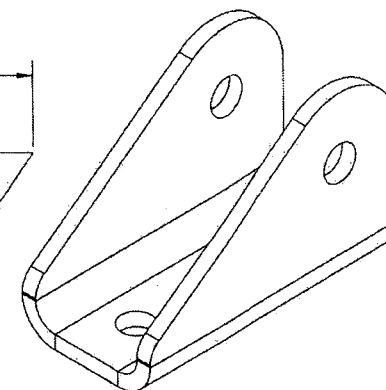
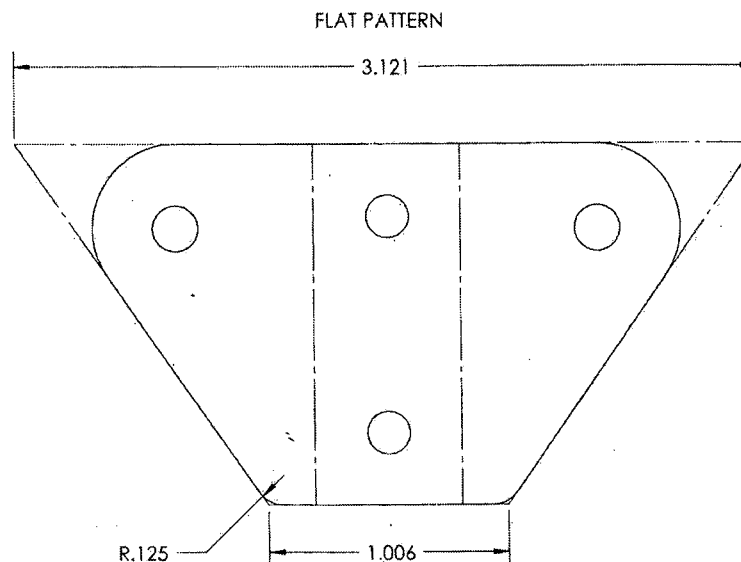
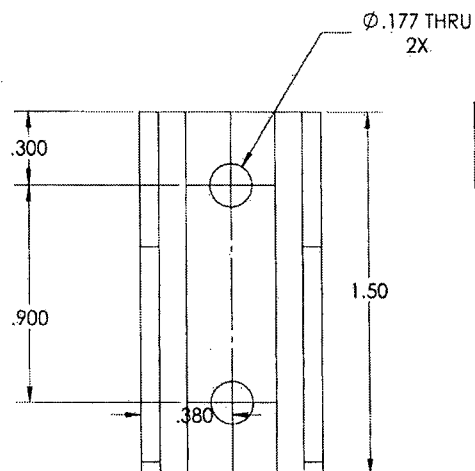
.063

R83.40

ORIGINAL DATE: 05/28/08 MODIFIED: 05/28/08 DRAWN BY: J. ROYAL CHECKED BY: P. BRAYO DRAWING APPROVAL: P. BRAYO CONTRACT NO:		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ± .01 3 PLACE DECIMALS ± .005 ANGLES ± .5°		SHEETMETAL SHEET 2 OF 5	
SHEET	CAGE CODE	DWG. NO.	REV.
B	07M26	647.0100	A
SCALE: NONE			

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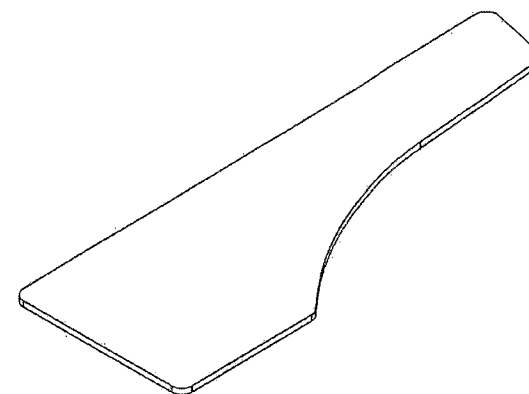
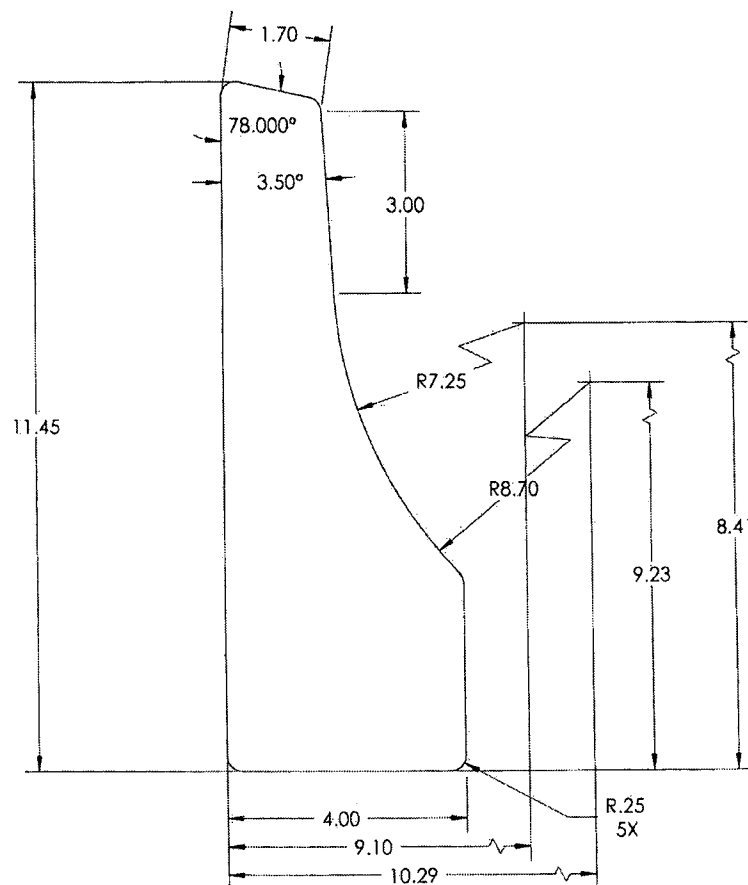
REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED



ORIGINAL DATE UNLESS OTHERWISE SPECIFIED		APICAL INDUSTRIES	
DRAWN BY R. ROJANO		2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300	
CHECKED BY P. BRAVO		SHEETMETAL	
DRAWING APPROVAL P. BRAVO		SHEET 647.0100	
CONTRACT NO.		SHEET 3 OF 6	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES FRACTIONS ARE 2 PLACE DECIMALS ± .01 3 PLACE DECIMALS ± .005 ANGLES ± .5°		SCALE: NONE	

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REVISION			
REV.	DESCRIPTION	DATE	APPROVED

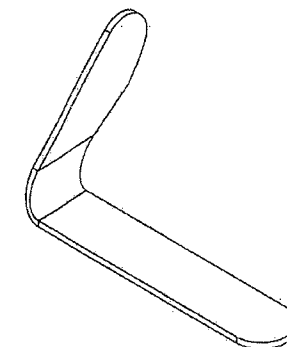


647.0113

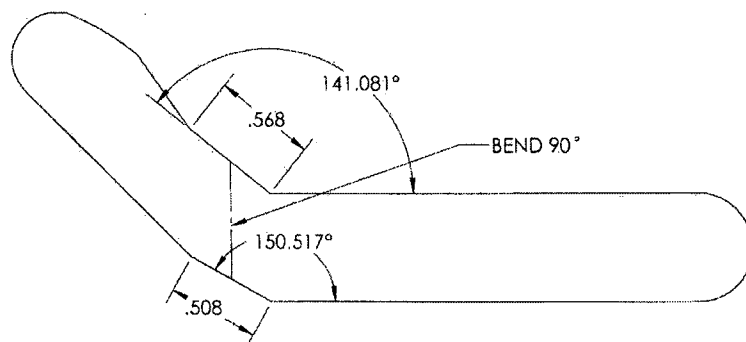
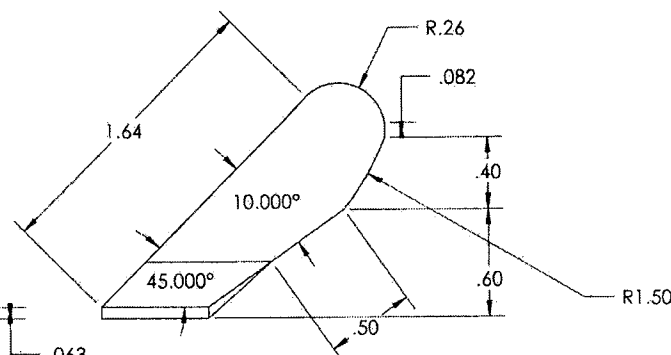
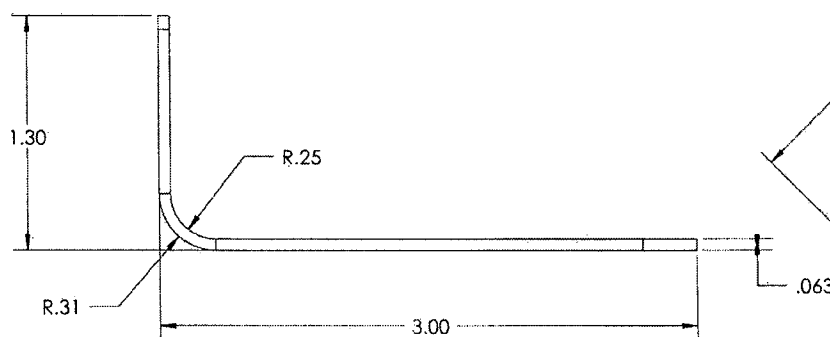
ORIGINAL DATE: 10/01/01		APICAL INDUSTRIES	
DRAWN BY: J. ROSS		2608 TEMPLE HEIGHTS DR.	
P. ROSSANO		OCEANSIDE, CA. 92056-3512 (760) 724-5300	
DRAWING APPROVAL:		SHEETMETAL	
P. ROSS		SHEET 4 OF 6	
10/26/01		SCALE: NONE	
CONTRACT NO:		DWG. NO. 647.010J	
UNLESS OTHERWISE SPECIFIED		REV. A	
DIMENSIONS ARE IN INCHES		SHEET 4 OF 6	
TOLERANCES ARE:			
2 PLACE DECIMALS ± .01			
3 PLACE DECIMALS ± .005			
ANGLES ± .5°			

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REVISIONS		
REV.	DESCRIPTION	DATE



647.0114 SHOWN
647.0115 OPPOSITE

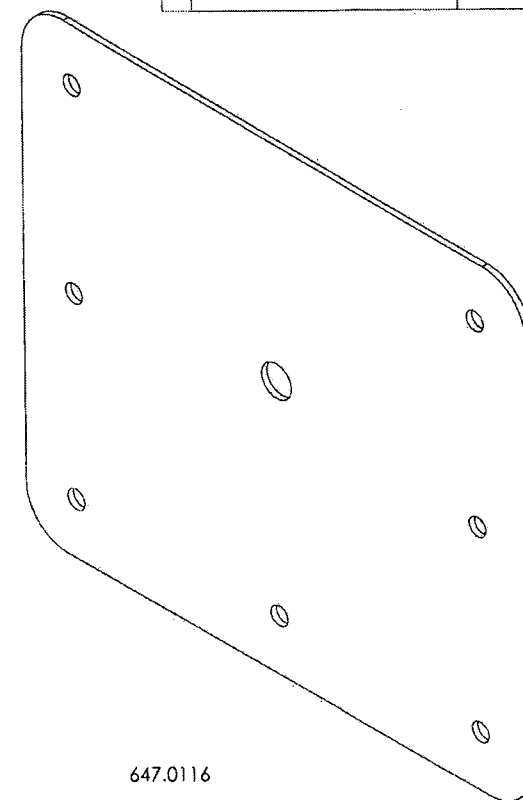
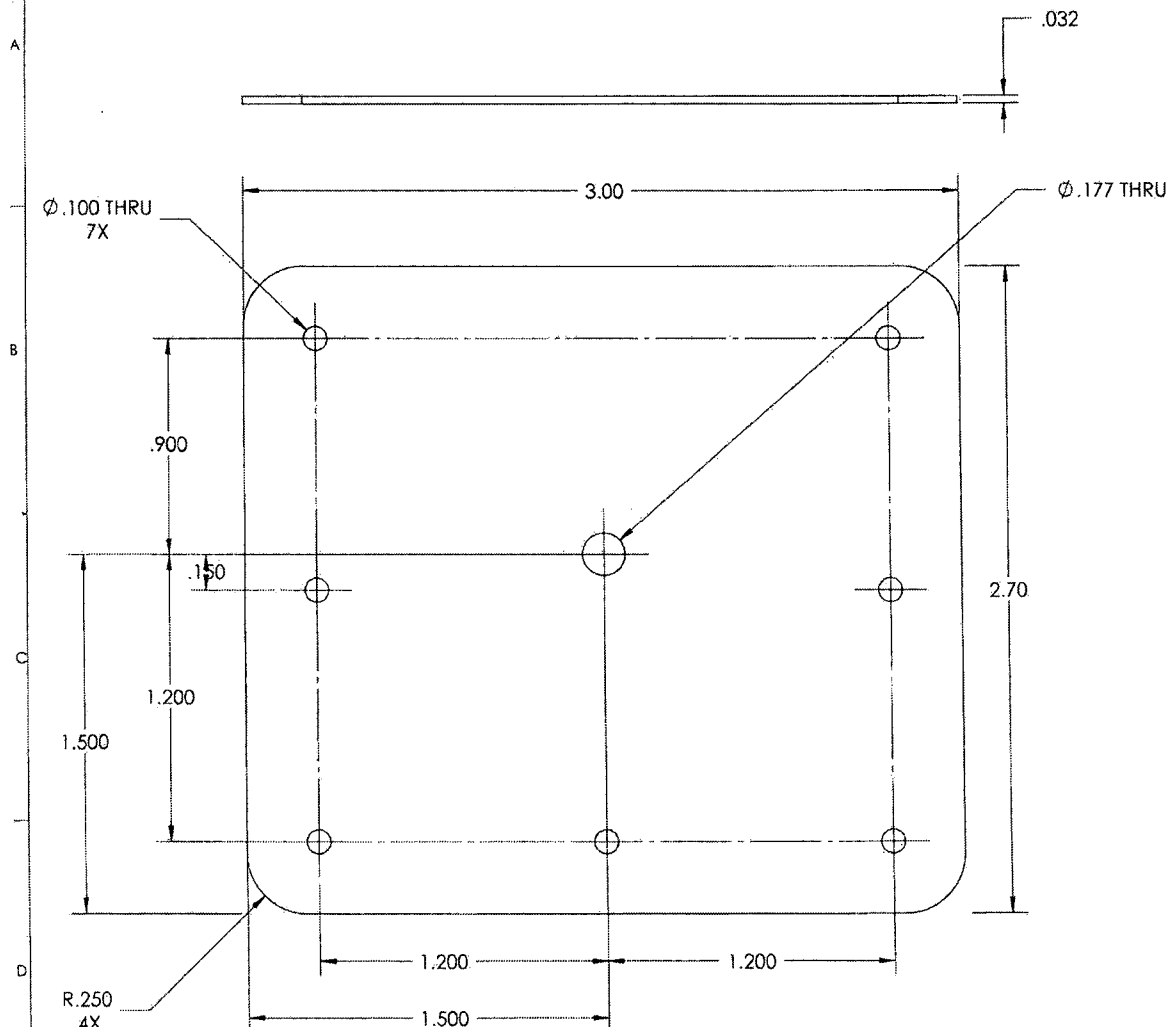


FLAT PATTERN

ORIGINAL DATE 12/01/04		APICAL INDUSTRIES	
DRAWN BY J. POZAND		2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300	
CHECKED BY J. BRAVO		SHEETMETAL	
DRAWING APPROVAL J. BRAVO		SIZE (CAGE CODE)	DWG. NO.
CONTRACT NO.		B 07M26	647.0100
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: FRACTIONS DECIMALS .01 ANGLES ± .5°		SCALE	SHEET 5 OF 6
		NONE	

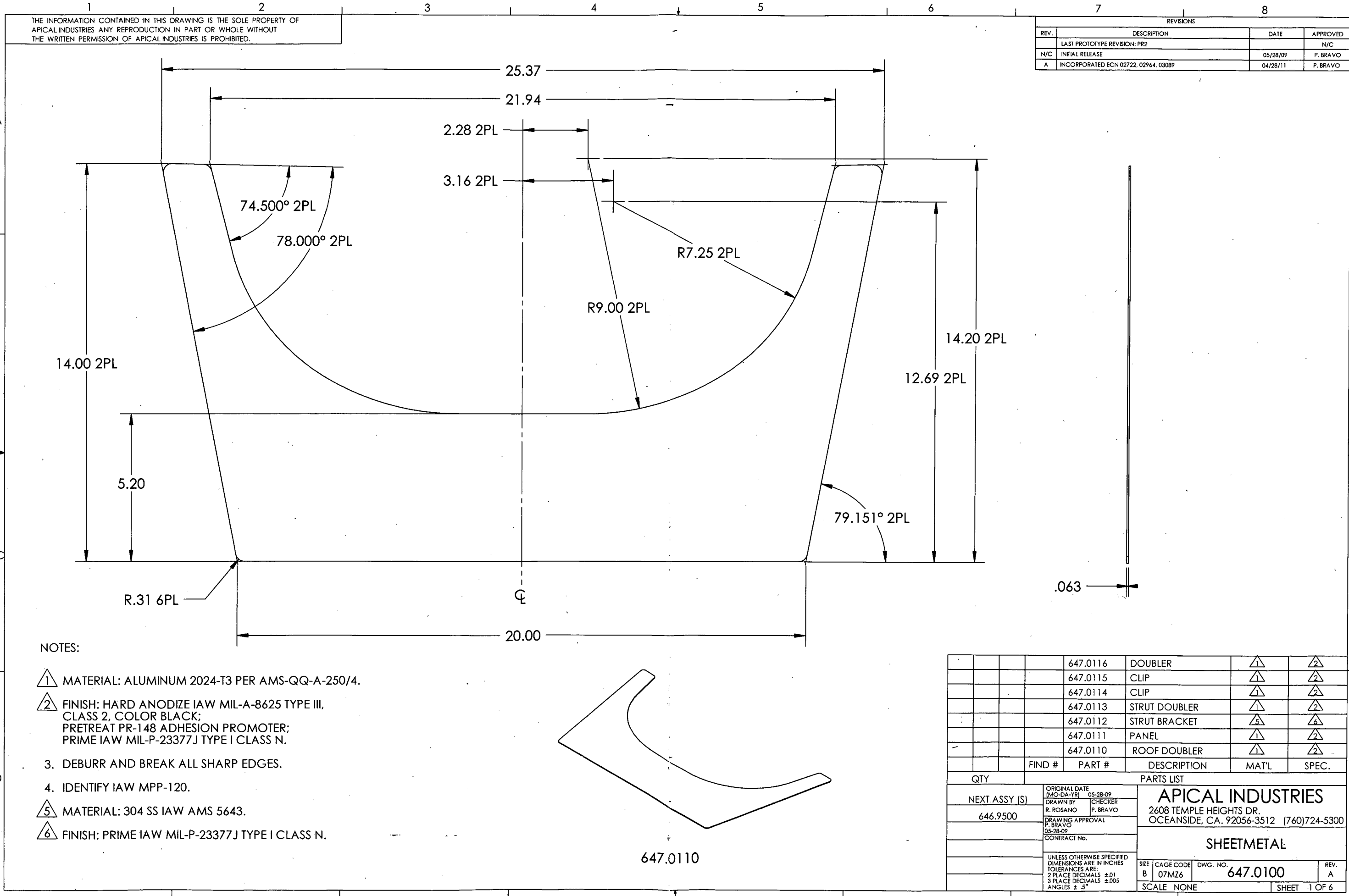
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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED



647.0116

ORIGINAL DATE: 08-08-00		APICAL INDUSTRIES	
DRAWN BY: J. HOLLAND		2608 TEMPLE HEIGHTS DR.	
CHECKED BY: P. HOLLAND		OCEANSIDE, CA. 92056-3512 (760) 724-5300	
DRAWING APPROVAL:		SHEETMETAL	
BY: VJC		SCALE: NONE	
DATE: 07/21/06		SHEET 6 OF 6	



NOTES:

- 1 MATERIAL: ALUMINUM 2024-T3 PER AMS-QQ-A-250/4.
- 2 FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK; PRETREAT PR-148 ADHESION PROMOTER; PRIME IAW MIL-P-23377J TYPE I CLASS N.
3. DEBURR AND BREAK ALL SHARP EDGES.
4. IDENTIFY IAW MPP-120.
- 5 MATERIAL: 304 SS IAW AMS 5643.
- 6 FINISH: PRIME IAW MIL-P-23377J TYPE I CLASS N.

			647.0116	DOUBLER	△	△
			647.0115	CLIP	△	△
			647.0114	CLIP	△	△
			647.0113	STRUT DOUBLER	△	△
			647.0112	STRUT BRACKET	△	△
			647.0111	PANEL	△	△
			647.0110	ROOF DOUBLER	△	△
		FIND #	PART #	DESCRIPTION	MAT'L	SPEC.
	QTY			PARTS LIST		
	NEXT ASSY (S)	ORIGINAL DATE (MO-DA-YR)	05-28-09	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300		
	646.9500	DRAWN BY	R. ROSANO			
		CHECKER	P. BRAVO			
		DRAWING APPROVAL	P. BRAVO			
		05-28-09		SHEETMETAL		
		CONTRACT NO.				
		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE:		SIZE	CAGE CODE	DWG. NO.
		2 PLACE DECIMALS ±.01		B	07MZ6	647.0100
		3 PLACE DECIMALS ±.005		SCALE	NONE	SHEET 1 OF 6
		ANGLES ±.5°				